

Work Order ID 81123-2

81123

Page 1

March-08-12 8:54:25 AM

Item ID: D3560-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 08/03/2012 Start Qty: 6.00

*6*3

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

*6*3

Customer:

Reference:

Approvals: Process Plan: MLC

Date: 12/03/09 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

mk 12/04/01

6 15

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D
 2-C'sink 0.196" hole on manual mill as per dwg D3560
 3-Deburr per dwg D3560

BA 12/04/07

6

12-4-10

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 12/04/08

6

407

W/O: 81123-2

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3560-041 PAR #: _____ Fault Category: Machining NCR: Yes No Yes DQA: OK Date: 12/04/04
12-1393 Resolution: Scrap Disposition: Scrap QA: N/C Closed: OK Date: 12/5/7

NCR:		WORK ORDER NON-CONFORMANCE (NCR) 166.82						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/04/08	110	→ counterbore ϕ is .509 instead of ϕ .507 +0.001/-0.001 → offset has been put on radius instead of diameter <u>RC</u> → operator error	<u>JP</u> 12.04.11 <u>PS/0412</u>	SCRAP. replace Qty 1 Batch <u>M121040</u> BUSHING TOO LOOSE. NOT WORTH MAKING CUSTOM BUSHING	B.A 12/04/08	<u>OK</u> 12/04/11	<u>JP</u> 12.04.11 <u>PS/0412</u>	<u>So</u> 12/11/11

NOTE: Date & initial all entries

Work Order ID 81123

March-08-12 8:54:25 AM

81123

Page 2

Item ID: D3560-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 08/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check 0.00

130

QC

Quality Control

Memo

0.00

OK 12/04/11

6

0

140 0.00

140

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Weld assembly as per dwg D3560
 STEP:
 1- clean material (buff bracket and bottom of arm with blue pad)
 2- set up bracket and arm on jig
 3- preheat bracket and arm with torch
 4- clean before welding with brush
 5- set up machine to 135 amps
 6- weld across bottom and top ends
 7- reheat with torch (65 deg C)
 8- on one side weld from bottom to top half way
 9- same for other side (half way)
 10- from half way point weld the rest of the first side (ease off pedal near end)
 11- same for remaining side (ease off pedal near end)

Alum. Rod # M120354

3

0

12.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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 Start Date: 08/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 22/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.00							
Hand Finishing									

5/26/30

3
73
041

3 *0* *DE 12/04/30*

3 *NG 12-5-1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 4

Item ID: D3560-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm Weldment

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

3x

0

SB 12/05/01

190

Small Fab

0.00

190

Small Fab

Memo

0.00

Small Fab

1-Press bushing in D3560 arm per dwg D3562

3x

0

SB 12/05/01

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

3

SB 12/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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 Item Name: Arm Weldment
 Start Date: 08/03/2012 Start Qty: 6.00
 Required Date: 22/03/2012 Req'd Qty: 6.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: Date: Tooling: Date:
 QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: WA	0.00							
210	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220	Memo	0.00							
QC									
Quality Control									

3

Ae
12.05.01

12/5/1

ME
12-05-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-08-12 8:54:29 AM

Page 1

Work Order ID: 81123

81123

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808		Manufactured	No			100	Each	35.0000	1	6			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2808

Bushing

Location

Loc Qty

Loc Code

GA

35

32896

2

79688

33

M6061T6B0.500X05.00
0

Purchased No

140

f

75.2274

1.395

8.810526

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

**

Location

Loc Qty

Loc Code

MAT001

21.834

112154

6.935

117933

2.123

119346

12.776

MAT004

53.3934

120243

24

120421

5.3934

120866

24

M121040 X 8.82

OK 12/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

March-08-12 8:54:29 AM

Page 2

Work Order ID: 81123

81123

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3592-1

Manufactured

No

190

Each

17.0000

1

6

D3592-1

**

12.04.30

Plate

Location

Loc Qty

Loc Code

WA

B80379

15

79715

15

WA002

2

47015

2

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81123
Description: Arm		Part Number:	D3560-1
Inspection Dwg: D3560	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.507	+0.000/-0.001	Ø0.5063	✓		Mic	GA-03
Ø0.196	+0.005/-0.001	Ø0.198	✓		Vern	GA-01
Ø1.000	+0.010/-0.001	Ø1.004	✓		"	"
0.500	+/-0.010	0.495	✓			
0.250	+/-0.010	0.251	✓			
0.275	+/-0.010	0.277	✓			
0.188	+/-0.010	0.190	✓		Mic	GA-03
2.000	+/-0.010	1.999	✓		Vern	GA-01
1.700	+/-0.010	1.700	✓		"	"
Ø0.385 x 100°	+/-0.010 x 0.5°	Ø0.385x100°	✓		"	"
0.250 Deep	+/-0.010	0.250	✓		"	"

Measured by: B.A. 10	Audited by: [Signature]	Prototype Approval:	N/A
Date: 12/04/08	Date: 12/04/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue P/O D3560-041	KJ/JLM	
B	07.06.13	Dimensions updated per Dwg Rev B	KJ/JLM	
C	08.07.24	Dwg Rev updated	KJ/DD	[Signature]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

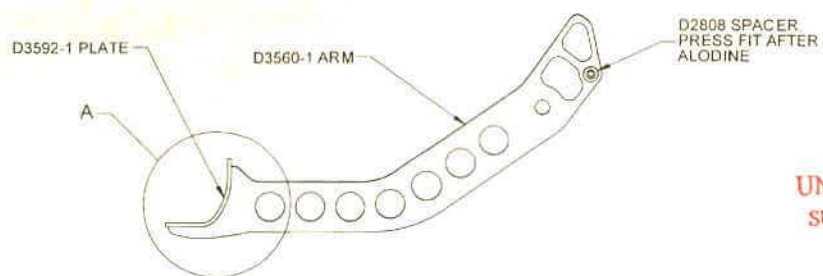
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

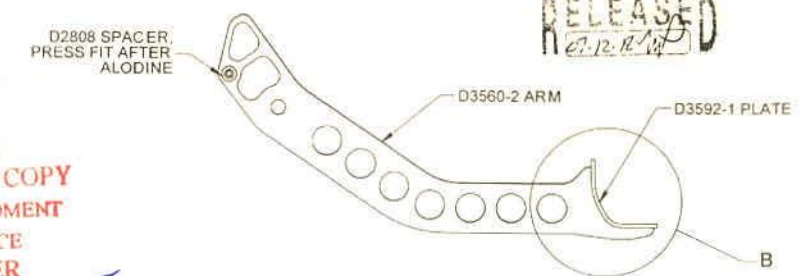
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27.12.12

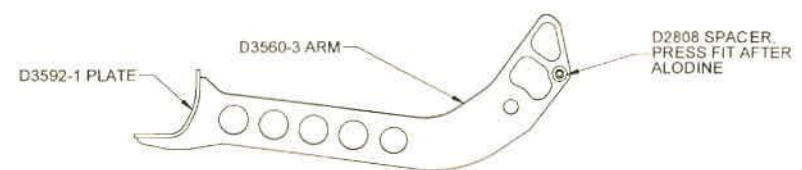
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 81123 *MLJ*
12103109



D3560-041 ARM WELDMENT



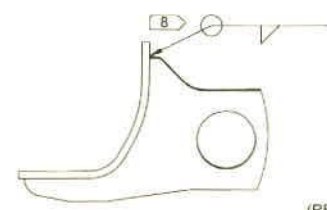
D3560-042 ARM WELDMENT



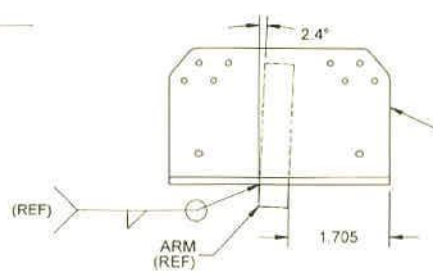
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT

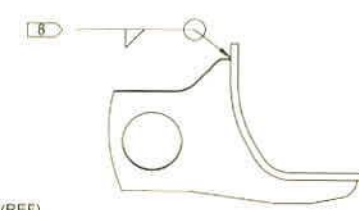


DETAIL A
SCALE 1:2



PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE



DETAIL B
SCALE 1:2

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

DESIGN	ADD D2808 PRESS FIT NOTE, REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG APPR	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D SHEET 1 OF 5
TITLE ARM WELDMENT SCALE 1:4	
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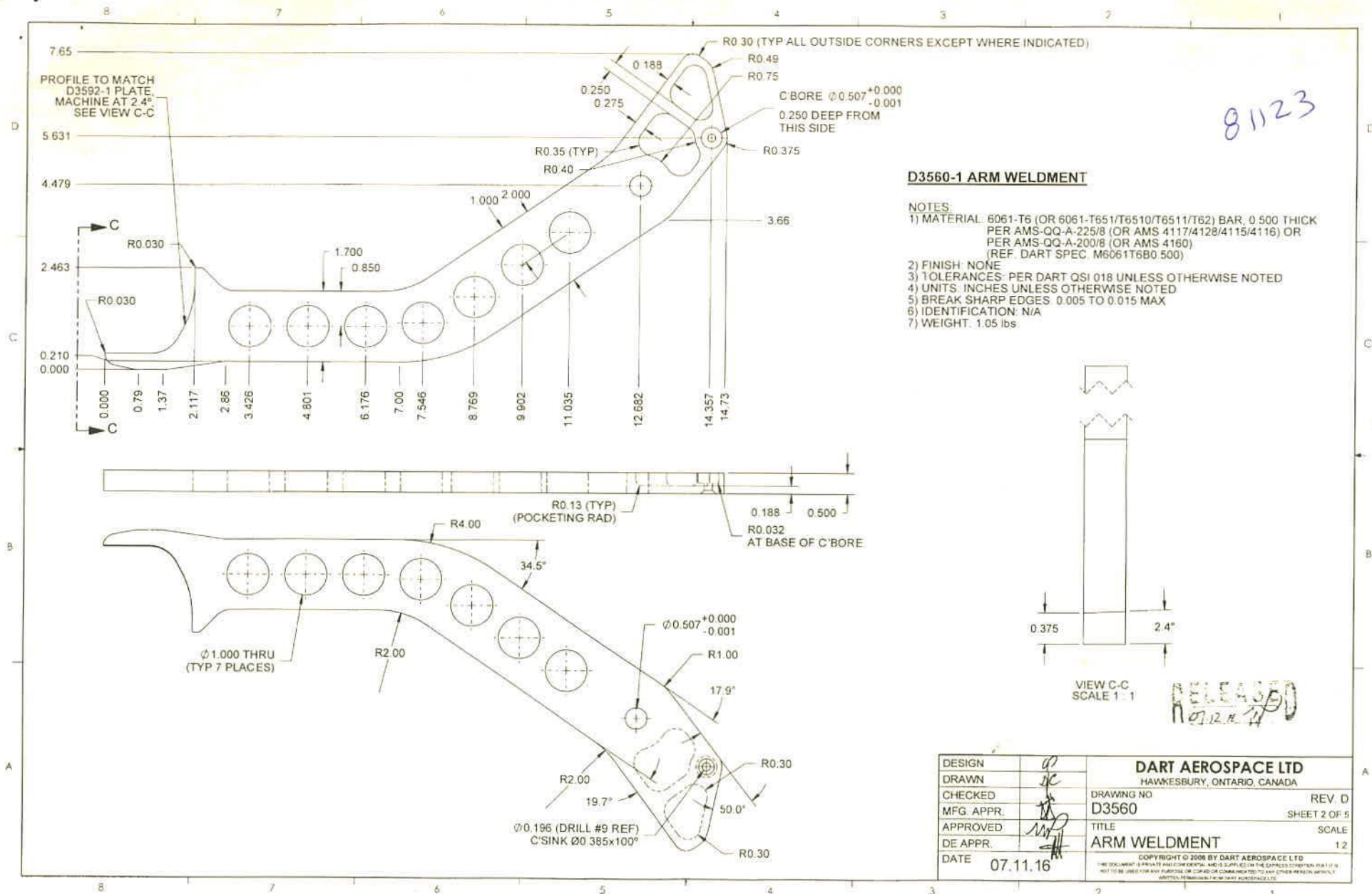
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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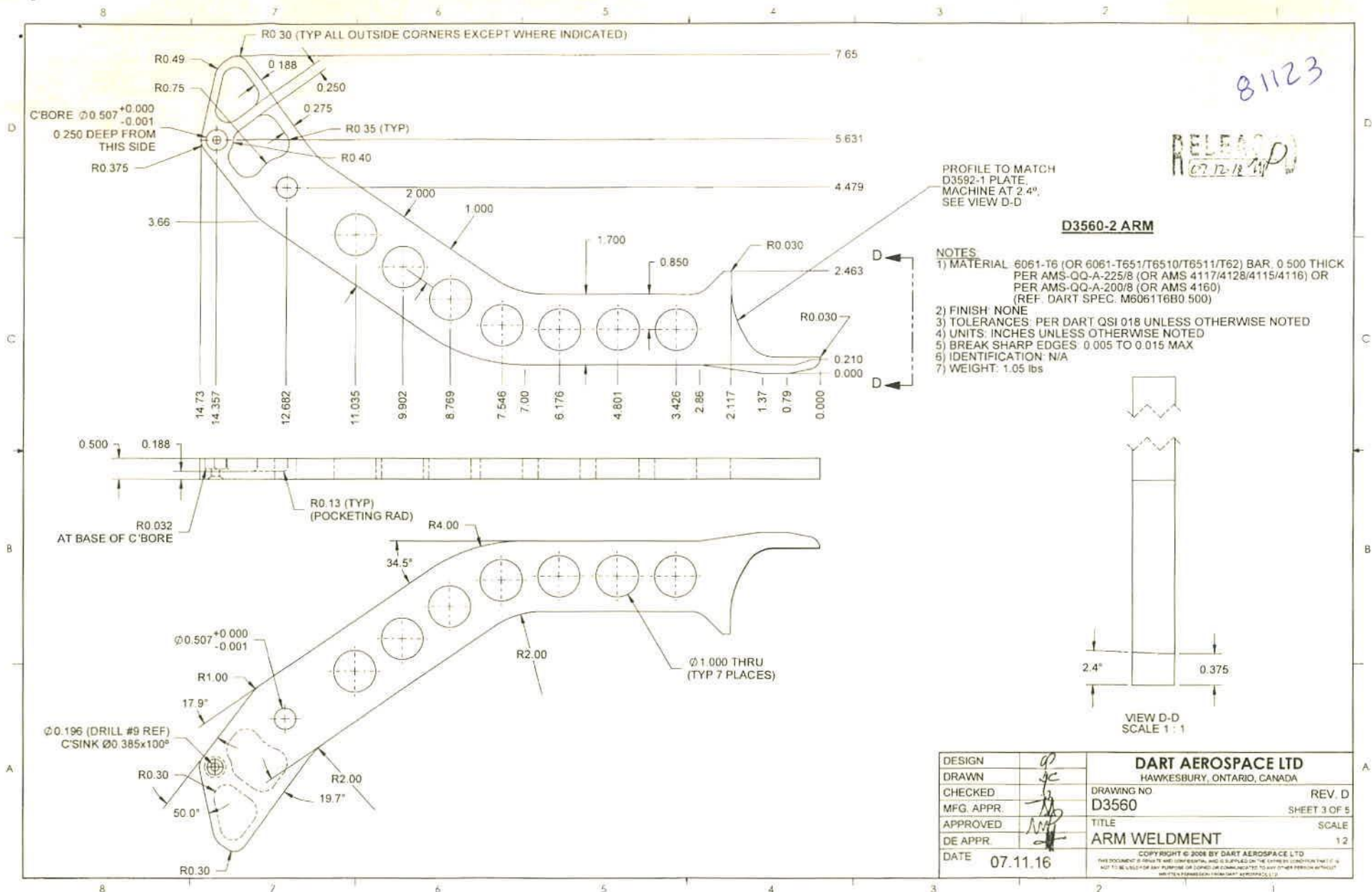
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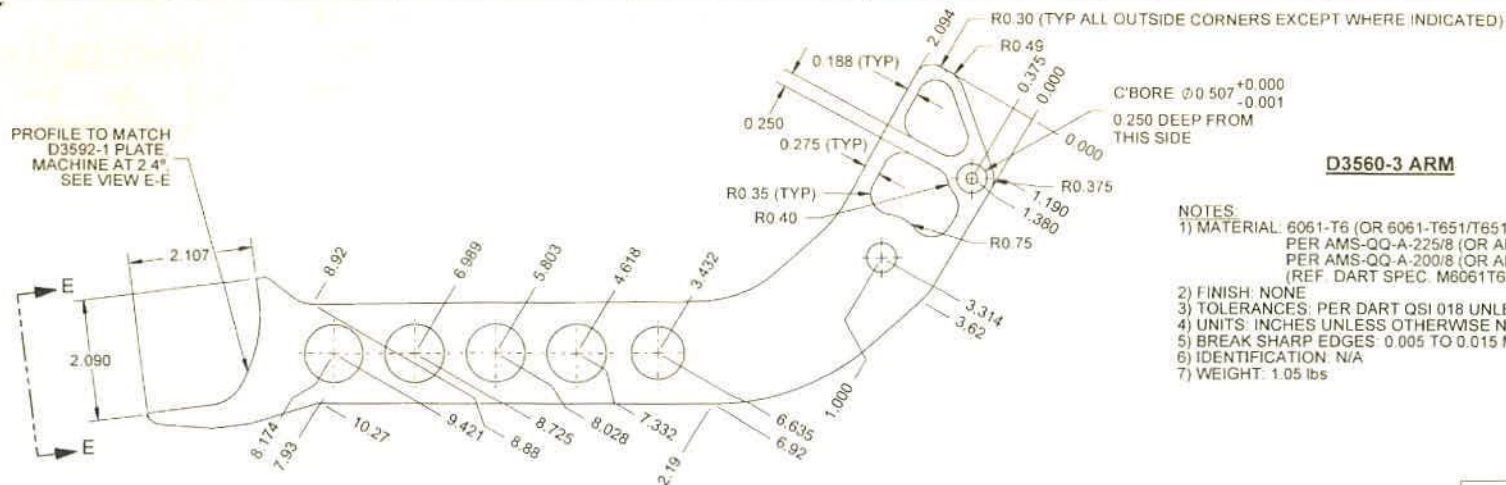
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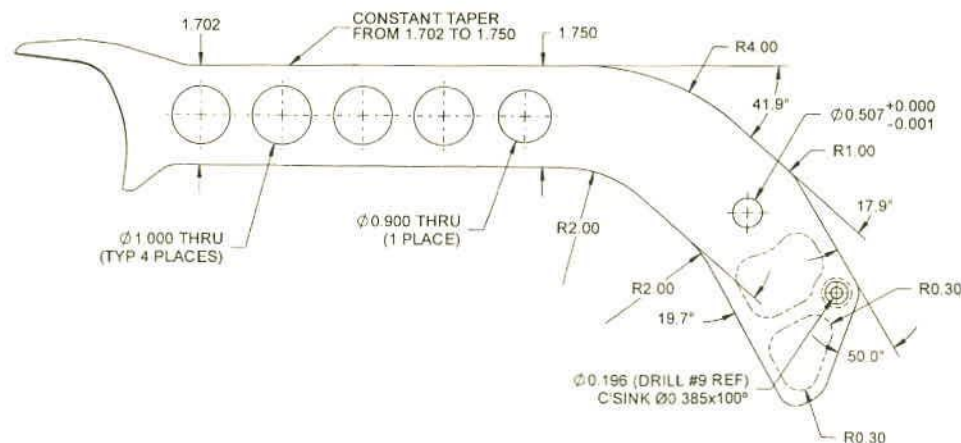
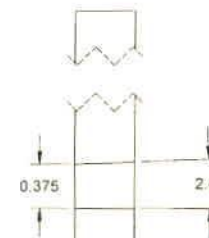
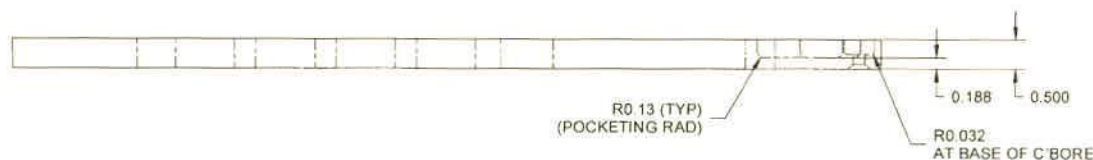
NOTE: Date & initial all entries

PROFILE TO MATCH
D3592-1 PLATE
MACHINE AT 2.4"
SEE VIEW E-E



D3560-3 ARM

- NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.500)
2) FINISH: NONE
3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs



DESIGN	JP	DART AEROSPACE LTD	
DRAWN	AC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. D
MFG. APPR.	JP	D3560	SHEET 4 OF 5
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

81123

107-12-14 JP

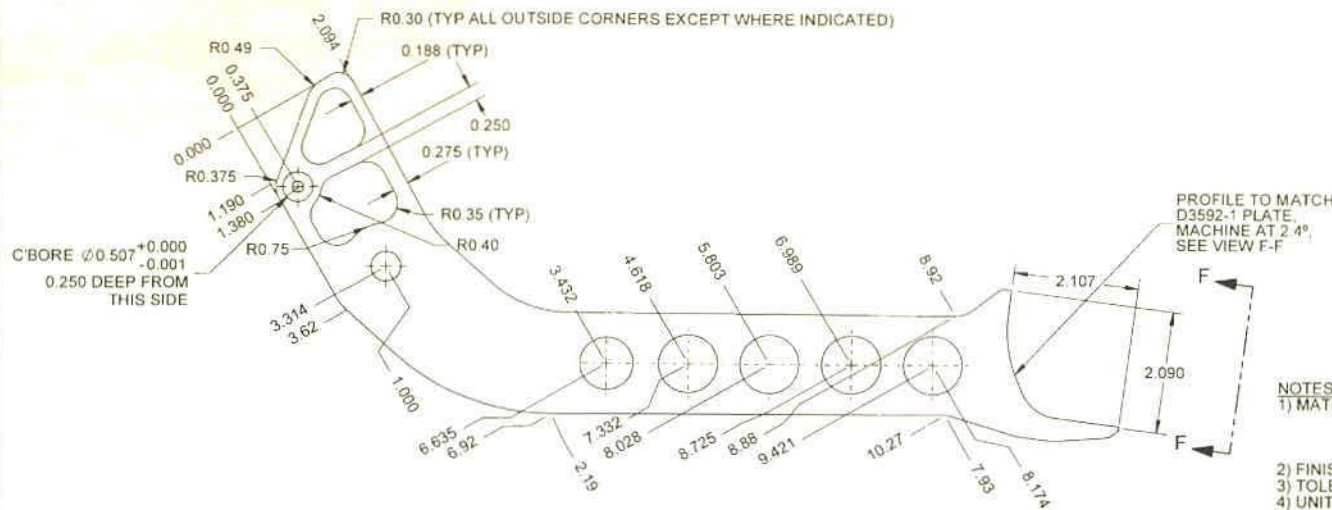
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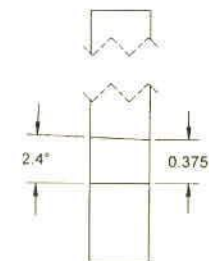
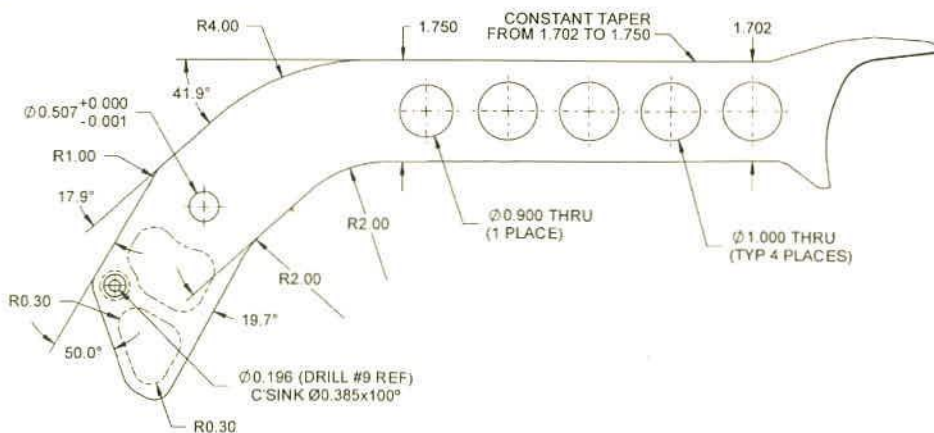
D3560-4 ARM

NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) (REF: DART SPEC. M6061T680.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



R0.032
AT BASE OF C'BORE



VIEW F-F
SCALE 1:1

DESIGN		DART AEROSPACE LTD	
DRAWN	EC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries